

# Work Order ID 70474

Thursday, June 09, 2011 10:01:35 AM

Page 1

Item ID: D4038-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle, Fwd, RH

Start Date: 6/9/2011 Start Qty: 10.00

Required Date: 6/23/2011 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4038	E
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100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank 7.125" long

110

0.00



HAAS CNC vertical machine #1

Memo

0.00

Mill as per Dwg & Folio FA880

Dwg Rev:

Folio Rev:

Deburr

issue P/O: 14260

Dan's Precision Machine as per dwg.  
D4038 REV. E

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Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120 *rec'd*



QC  
Quality Control

QC2 - ~~Inspect parts off machine FAI/FAIB~~

0.00

Memo

0.00

*rec'd + inspect for transit damage.  
attached c/c to W10*

*06/17/05* *(4)*

130



QC  
Quality Control

QC2 - Inspect parts - second check

0.00

Memo

0.00

*S wlog 7/05*

*(+4)*

140



HandFinish  
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

*4* *06/20/05*

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Start Date: 6/9/2011 Start Qty: 10.00

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4x *[Signature]* 11/07/05

160

Identify as per dwg & Stock Location *114*

0.00



Packaging

Memo

0.00

Packaging

*11/7/06 [Signature]*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/7/06 [Signature]*  
*MF*  
*11-07-06*

# Picklist Print

Thursday, June 09, 2011 10:01:31 AM

Page 1

Work Order ID: 70474



Parent Item: D4038-2



Parent Item Name: Angle, Fwd, RH

Start Date: 6/9/2011

Required Date: 6/23/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6A4.000W.250

Purchased

No

100

f

15.5745

0.7

7.368421



6061T6 ANGLE 4.00 x 4.00 x .250

Location

Loc Qty

Loc Code

MAT006

14.29

117285

14.29

MAT007

1.2845

114507

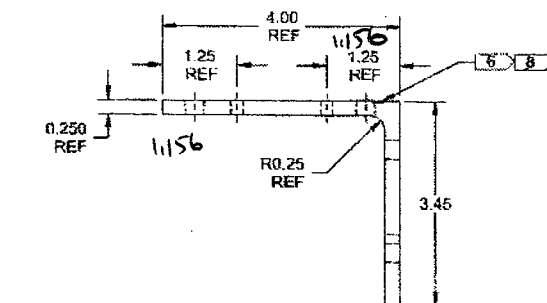
1.2845

2.25

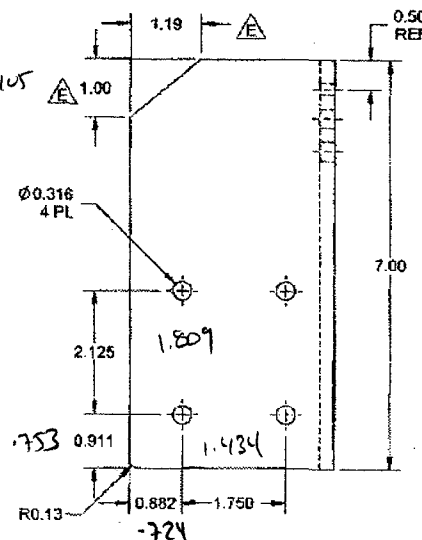
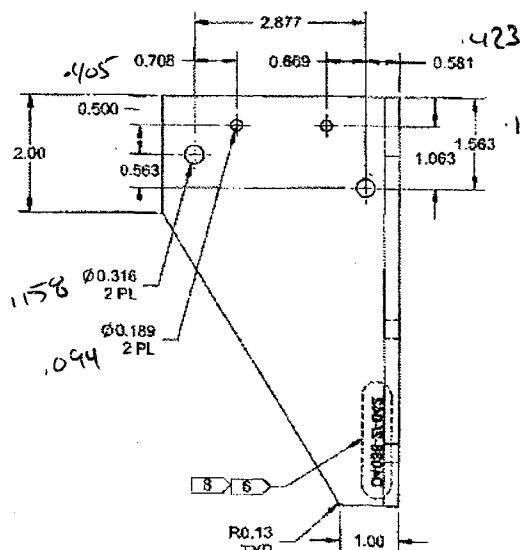
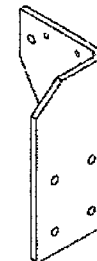
11/06/09

D4038-2 P

Pu 11/7/10 (4)



*w/o 70474*



**D4038-2 ANGLE, FWD, RH**

**NOTES:**

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250  
PER AMS-QQ-A-200/8  
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX  
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.03 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

**RELEASED**  
R 2011-04-20  
*JMD*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		<b>D4038</b>	SHEET 4 OF 14
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
DATE	<b>11.04.11</b>	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED UNLESS OTHERWISE NOTED ALL RIGHTS ARE RESERVED FOR DART AEROSPACE LTD</small>	

**DAN'S PRECISION TOOLS INC.**

2560 Devine Road, Vars, ON K0A3H0  
Tel: (613) 835-3097 Fax: (613) 835-3760  
support@dans-precision-tools.com

**RE: CERTIFICATE OF COMPLIANCE**

**To:** DART AEROSPACE LTD.  
1270 Aberdeen Street  
Hawkesbury ON K6A-1K7  
Tel: (613) 632-5200  
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

**Date** : 04-Jul-11

**Purchase Order** : PO14260

**Packing Slip** : 10537

**Part Number** : D4038-2revE

**Quantity** : 4

8 Jul 11

Per: \_\_\_\_\_

For Dan's Precision Tools Inc.

**DAN'S PRECISION TOOLS INC.**

Customer: DART AEROSPACE

P.O.: PO14260

W/O: \_\_\_\_\_

Part #: D4038-2 rev E

Bracket, Angle, FWD, RH

Qty: 4

1

of

1